

Work Order ID 129354

February-04-15 11:19:46 AM

129354

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Item ID: D5203-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Weldment

Stop *NS2*

Start Date: 2/04/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/13/15 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5203

A

110

Weld per dwg A/R S.S. rod Batch: M123823 0.00

110

Large Fab

Memo

0.00

Large Fab

Weld stud to strut as per dwg

GRIND WELD FLUSH

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

6 FL 15-2-10

6 15-02-12

DAS
9
3-89

6 15-02-12

DAS
9
3-89

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

140

0.00

Small Fab

Memo

0.00

Small Fab.

Assemble nut and clevis as per dwg (HAND TIGHTEN NUT) use anti-seize on thread.

A/R ANTI-SEIZE BATCH: M128063

150

QC5- Inspect part completeness to step on W/O	0.00
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0.00

OC

Memo

0.00

Quality Control

DAS
38
9-89

FEB 12 2015

160

Identify as per dwg & Stock Location: G.A 0.00

0.00

Packaging

Memo

0.00

Packaging

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15/2/18

15.2-18

Picklist Print

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Work Order ID: 129354

129354

Parent Item: D5203-045

D5203-045

Parent Item Name: Strut Weldment

Start Date: 2/04/15

Required Date: 2/13/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 15.01.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN665-34R		Purchased	No				Each	16.0000		12			
AN665-34R									**				
Clevis													

Location Loc Qty Loc Code

ST330 16

M126180 16

D4794-3		Manufactured	No				Each	0.0000		12			
D4794-3									**				
Stud													

D5203-1		Manufactured	No				Each	0.0000		6			
D5203-1									**				
Strut													

NAS509-4C		Purchased	No				Each	19.0000		12			
NAS509-4C									**				
NUT													

Location Loc Qty Loc Code

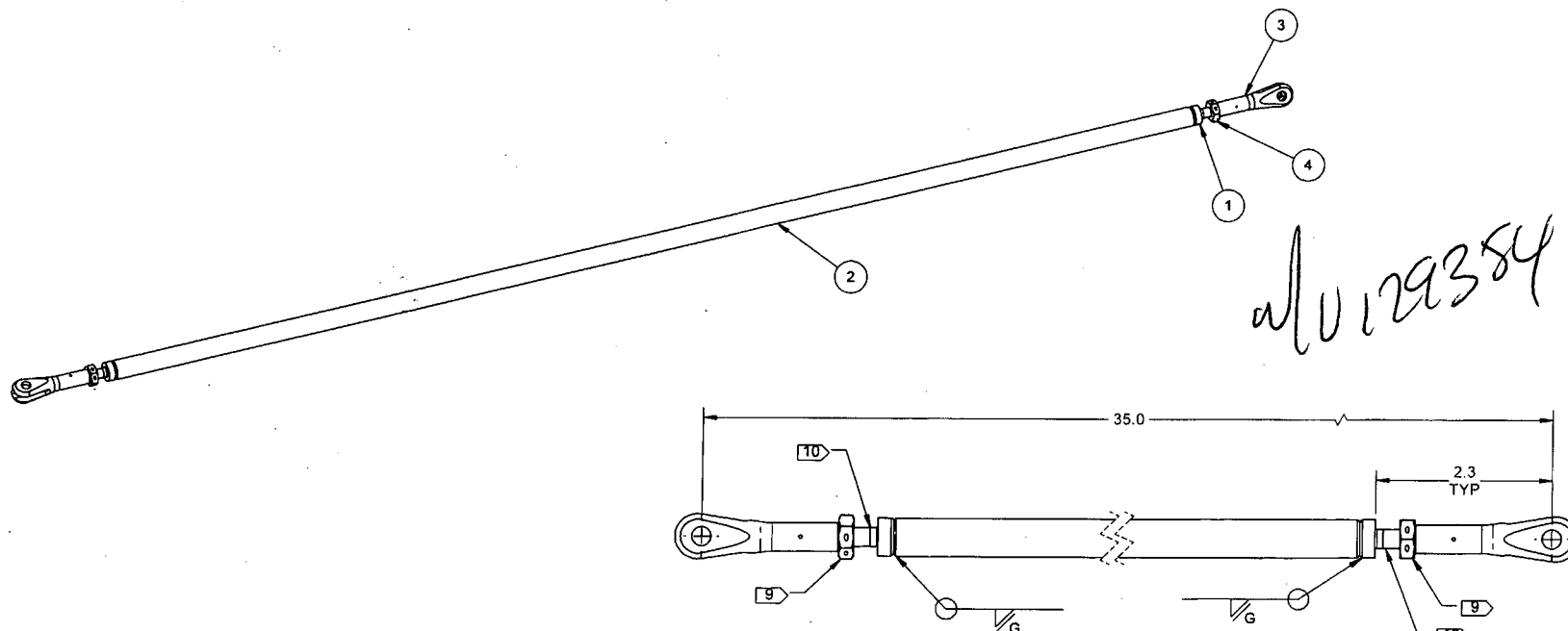
ST262 19

M127549 3

M130358 6

M130466 10

ITEM	QTY -045	P/N	DESCRIPTION
	X	D5203-045	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5203-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5203-045 STRUT WELDMENT

RELEASED

2015 JAN 29

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5203	SHEET 2 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STRUT ASSEMBLY	NTS
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